

Date: Monday, 2/6/2006 11:28:18 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACK	
Job Number	: 25724		Part Number	: D32501	
Estimate Number	: 10879		Drawing Number	: D3250 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/6/2006 S.O. No. : N/A		Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A Type : PURCHASED PARTS		Due Date	: 2/13/2006 Qty: 1 Um: Each	
Previous Run	: N/A				
Written By	: SEE COMMENT Below				
Checked & Approved By	: J				
Comment	: Est. B 04.10.26 D3250-1 no longer made in-house				

Additional Product

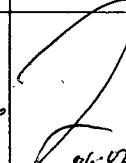
Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE BY HAND RECORD MATERIAL, QTY AND BATCH NUMBER DEBURR AND BEND PER DRWG	SB 06/02/06	PTO
2.0	QC6	DIMENSIONAL CHECK		
		Comment: DIMENSIONAL CHECK		2006-02-06
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr	SB 06/02/07	
4.0	QC5	INSPECT WORK TO CURRENT STEP		
		Comment: INSPECT WORK TO CURRENT STEP		2006-02-07
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1		
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	HF 06 02 07	
6.0	POWDER COATING	POWDER COATING		
		Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	FC 06 02 07	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/02/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/02/07	1	I piece was scrap missing radius on the drawing.		Scrap ~ destroy replace	SB 06/02/07	 06-02-07	 06-02-07	 06-02-07

NOTE: Date & initial all entries

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7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C2060207 ①

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ✓

C2060207 ①

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/02/07

Job Completion



06-02-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

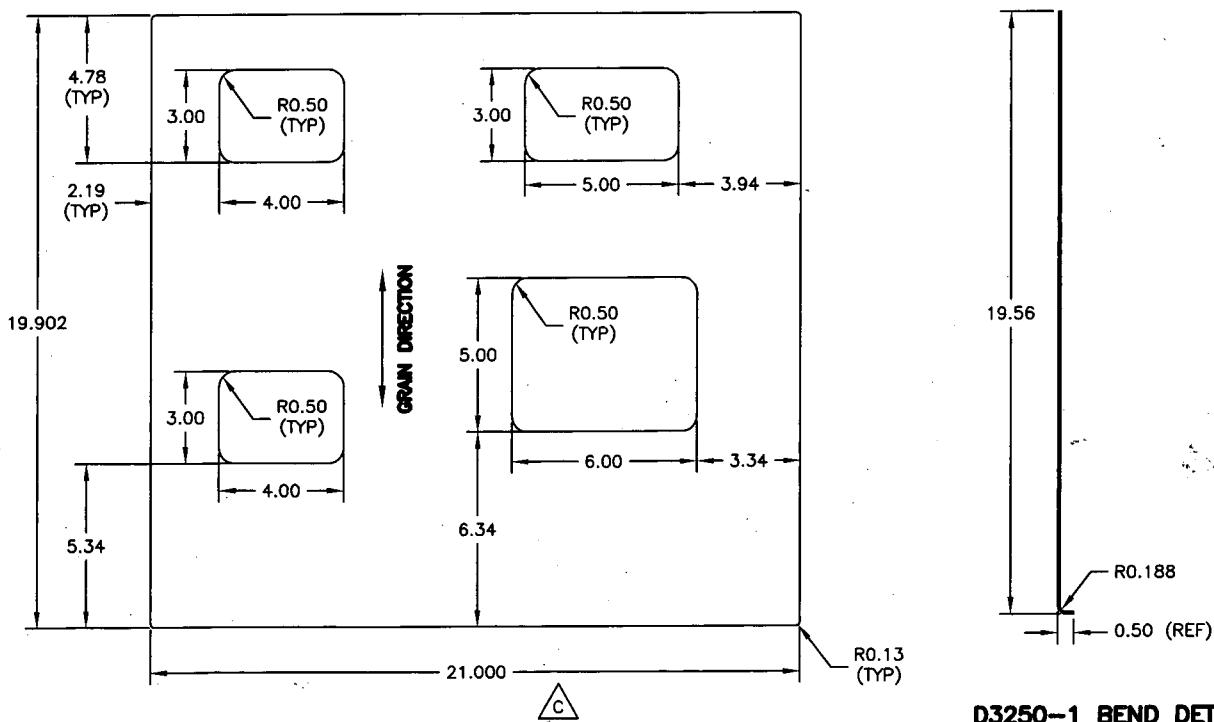
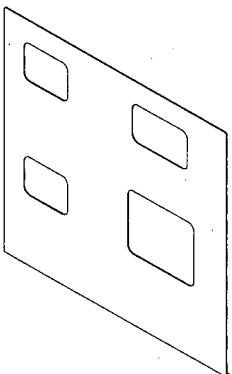
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
06.02.01		D3250	SHEET 1 OF 1
DATE		TITLE	SCALE
06.02.01		BACK (DUAL BATTERY RACK)	1:6
A	04.04.06	NEW ISSUE	
B	04.11.04	20.625 WAS 20.243	
C	06.02.01	20.875 WAS 20.625, REMOVE Ø0.501 TOOLING HOLES	



D3250-1 BEND DETAIL

D3250-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

Linda Lacelle

From: Jason Loader [mailto:jloader@eaglecopters.com]

Sent: Monday, February 06, 2006 4:21 PM

To: 'Linda Lacelle'

Subject: RE: D205-579-015 Dual Battery Rack

Yes, this one will finish their current completion. The production run in 4-6wks will give lots of time for their next completions.

Jason

-----Original Message-----

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: Monday, February 06, 2006 9:20 AM

To: 'Jason Loader'; 'Marc Bellavance'; 'Peggy McDonald'

Cc: 'Bill Beckett'

Subject: RE: D205-579-015 Dual Battery Rack

We will make one by hand, do you only need the one of each?

-----Original Message-----

From: Jason Loader [mailto:jloader@eaglecopters.com]

Sent: Friday, February 03, 2006 1:46 PM

To: 'Marc Bellavance'; 'Peggy McDonald'

Cc: 'Bill Beckett'; 'Linda Lacelle'

Subject: RE: D205-579-015 Dual Battery Rack

Ron at Heli-Trade is working on a completion of a 205 right now and requires the wider panels. He is hoping it might be possible to get the revised panels in about four weeks, 6 weeks will push it near the due date of the completion. He would much rather wait for the wider panels than install the kit with shims. Is there any chance of meeting this time frame?

Jason

-----Original Message-----

From: Marc Bellavance [mailto:mbellavance@dartaero.com]

Sent: Friday, February 03, 2006 11:35 AM

To: Peggy McDonald

Cc: Bill Beckett; Linda Lacelle; 'Jason Loader'

Subject: D205-579-015 Dual Battery Rack

Hi Peggy,

As per our last conversation, here are the part numbers:

- 1) D3249-1 Top Panel
- 2) D3250-1 Back Panel

We revised above flat patterns to extend the width of our Dual Battery Racks from 20.75" to 21.25".

According to Jason Loader, this should fix the problem of Heli-Trade.